

Work Order ID 83568

83568

Page 1

Thursday, April 19, 2012 3:38:56 PM

Item ID: D350-604-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Rear Locker Extender

Stop

NS2

Start Date: 4/19/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/18/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

l

Date: 1204-19 Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D2273	<i>T</i> F	
D350-604-041	B	<i>w</i>

100 *100* DOCUMENT CONTROL 50 0.00

DC Memo Photocopy bluefile and create labels per PPP D350-604-041 CHG004

for MLJ 12-9-25

110 *110* PURCHASING 0.00

Purchasing Memo Issue P/O: *16795 17636*
Purchasing Description: D350-604-041 Rear locker extender.
Supplier: Delastek.
Certification of Conformity and process sheet from Delastek is required.

04/16/12

CD 12104/23 Q
12/09/12 ①

4 x 2600-6 Camlock stud - Ship to Delastek B *121287*
4 x 2600-LW Retaining washers - Ship to Delastek B *121524*

122335
121524

#31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

120

120

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

DAS
16
9-63

2/18/14

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2/18/14

Check hole locations to template. DT 8824 Check process sheet and audit.

140

140

Small Fab

Small Fab

0.00

Memo

0.00

INSTALL DECALS AS PER DWG

12/18/14

W/O:		WORK ORDER CHANGES							
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Page 3

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Cust Item ID:

Required Date: 5/18/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

DA
16
8-25

17/04/25

150

QC

Quality Control

160

Packaging

0.00

160

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-604-041

Location: _____

PPP Rev: _____

4/29/25 C

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Quality Control

Memo

0.00

12/19/25 JH

MF
1209-25

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Page 1

• Thursday, April 19, 2012 3:39:00 PM

Work Order ID: 83568

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender

83568
D350-604-041

Start Date: 4/19/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R
12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.0
AS PER DWG REV.B DD VERF:EC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

Thursday, April 19, 2012 3:39:00 PM

Work Order ID: 83568

83568

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 4/19/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

D350-604-041P

Purchased

No

110

Each

0.0000

1

1

**

83568

D350-604-041P

Rear Locker Extender

D2268

Manufactured

No

140

Each

33.0000

1

**

54

D2268

Decal

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST007	20	
80010	20	
ST009	13	
69592	2	
78908	11	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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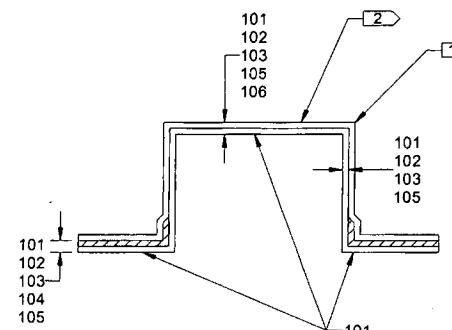
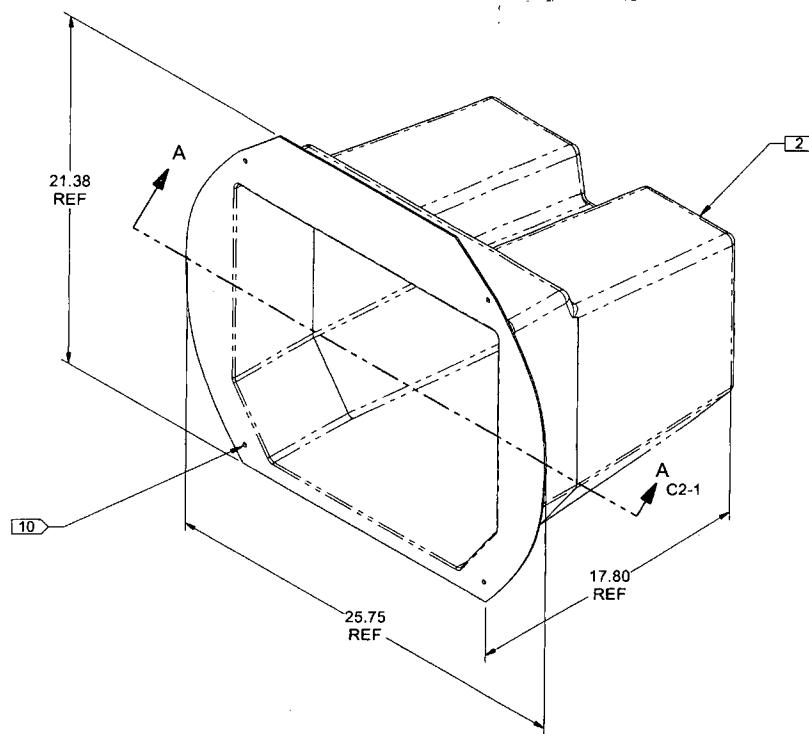
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83568

H12-04-1C



SECTION A-A
C4-1

RELEASED
2012-03-29

NOTES:

- 1) MATERIALS:
RESIN: DERAKANE 470-36/411/510A40
FIBRE: 9 oz = 9.7 oz 7781 WEAVE "S" GLASS
18 oz = 18.0 oz ROVING "E" GLASS
- 2) FINISH: FINISH THIS SURFACE WITH DUPONT GREY PRIMER LE 3404-S/LE 1175-S **F**
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 7.75 lbs
- 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 9) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACCUM
- 10) TRIM & DRILL PER DT8020. OPEN HOLES TO Ø0.257 (4 PLACES)
- 11) CONSTRUCTION:
101-WHITE GLOSS GELCOAT # GEL 2330PAWK745 TO MIN THICKNESS OF 0.020
102-9 oz ALL OVER
103-18 oz ALL OVER
104-18 oz REINFORCE FRONT FLANGE EXTENDING 2" ON SIDES
105-9 oz ALL OVER
106-PEEL PLY
12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

D2273 REAR LOCKER EXTENDER

F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT. ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	<i>DC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BS</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>HC</i>	D2273	SHEET 1 OF 1
APPROVED	<i>MF</i>	TITLE	SCALE
DE APPR.	<i>MF</i>	350 REAR LOCKER EXTENDER	NTS
DATE	12.02.27	COPYRIGHT © 1986 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

C

B

A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Linda Lacelle

From: dshepherd@dartaero.com
Sent: April-03-12 1:38 PM
To: Daniel Campbell; 'Linda Lacelle'
Cc: Harvey Siemens; Chantal Lavoie
Subject: Re: ECN D2273

Dan,

I think Delastek is confused. Leave the dwgs for now ... I don't care whether we use Rev E primer or Rev F primer ... My understanding is that your Rev F dwg represents what is procurable going forward.

David

Sent from my BlackBerry device on the Rogers Wireless Network

From: "Daniel Campbell" <dcampbell@dartaero.com>
Date: Tue, 3 Apr 2012 10:42:39 -0600
To: 'Linda Lacelle' <llacelle@dartaero.com>; <dshepherd@dartaero.com>
Cc: Harvey Siemens <hsiemens@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>
Subject: RE: ECN D2273

Hi,

I'm a little confused about this.

I thought we had checked back in Feb. and the 7704-S was discontinued and replaced with LE-3404-S / LE1175-S ?

Anyway, I can go back and update the following to call out 7704-S:

D604-350

1. D2273
2. ICA-D350-604

D605-206

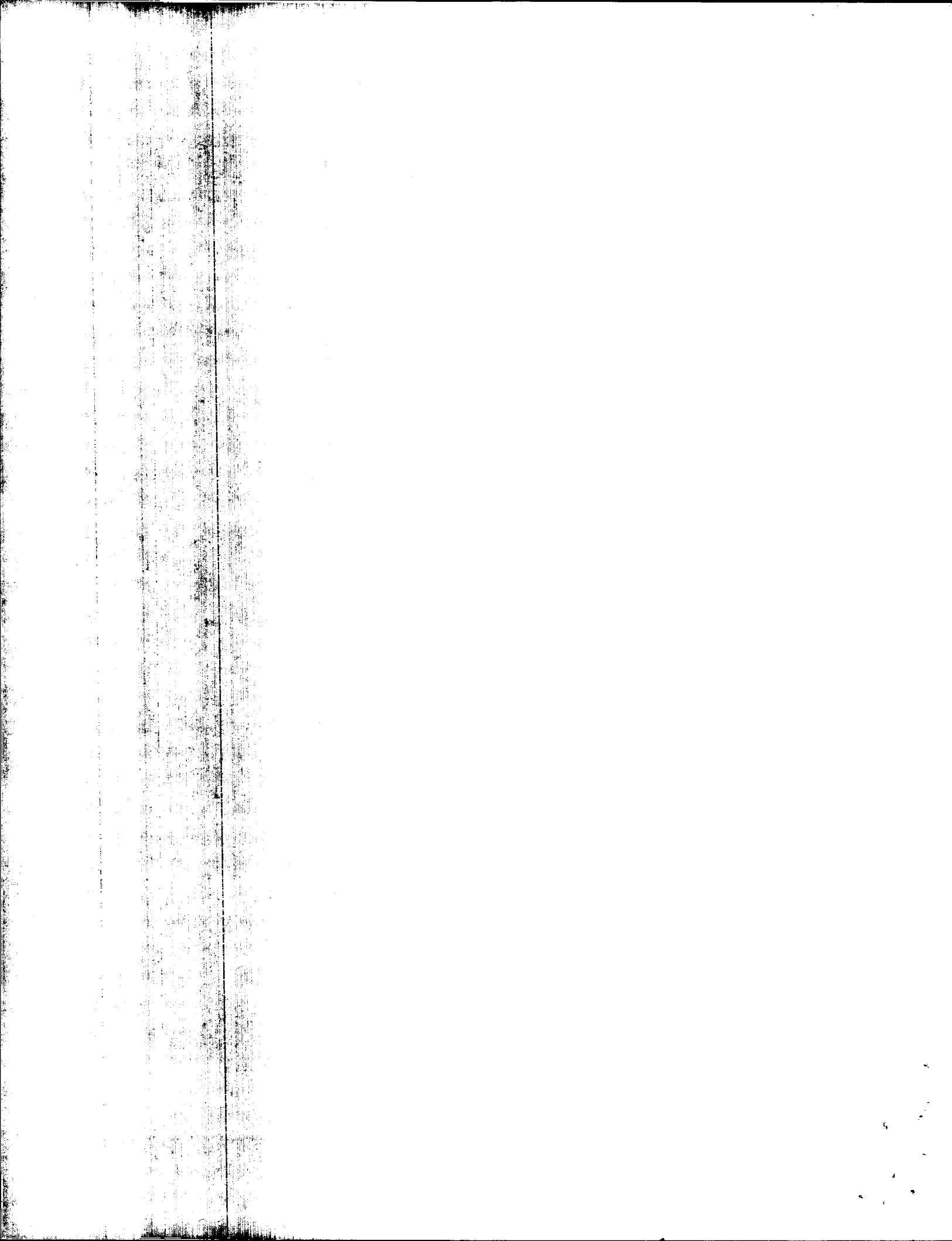
1. D2566
2. ICA-D605-206

I'm not sure if David is flying today - we might have to wait for him to weigh in.

Thanks,

Dan

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: April-03-12 10:00 AM
To: dshepherd@dartaero.com; Daniel Campbell
Subject: FW: ECN D2273



From: Jocelyne Laurin [mailto:JLaurin@delastek.com]
Sent: April-03-12 11:30 AM
To: Linda Lacelle
Cc: 'Chantal Lavoie'; Céline Audet
Subject: ECN D2273

Hello Linda,

For the Gel Coat we are presently using N° 2330PAWK745, Gel Coat Polycore Fireblock and for the primer Dupont Primer N° 7704S. Thank you and have a nice day.

Jocelyne Laurin

Agente Service à la clientèle/Customer Service Agent
DELASTEK INC.
jlaurin@delastek.com

De : Linda Lacelle [mailto:llacelle@dartaero.com]

Envoyé : 2 avril 2012 14:54

À : Jocelyne Laurin; 'Chantal Lavoie'

Cc : David Paradis; Céline Audet

Objet : RE: ECN D2273

Importance : Haute

Jocelyne,

This is the current primer you are using. We need to understand exactly what you are currently using. Please DO NOT stop production on the parts to ship this Thursday.

L

From: Jocelyne Laurin [mailto:JLaurin@delastek.com]

Sent: April-02-12 10:18 AM

To: 'Chantal Lavoie'; Linda Lacelle

Cc: David Paradis; Céline Audet

Subject: ECN D2273

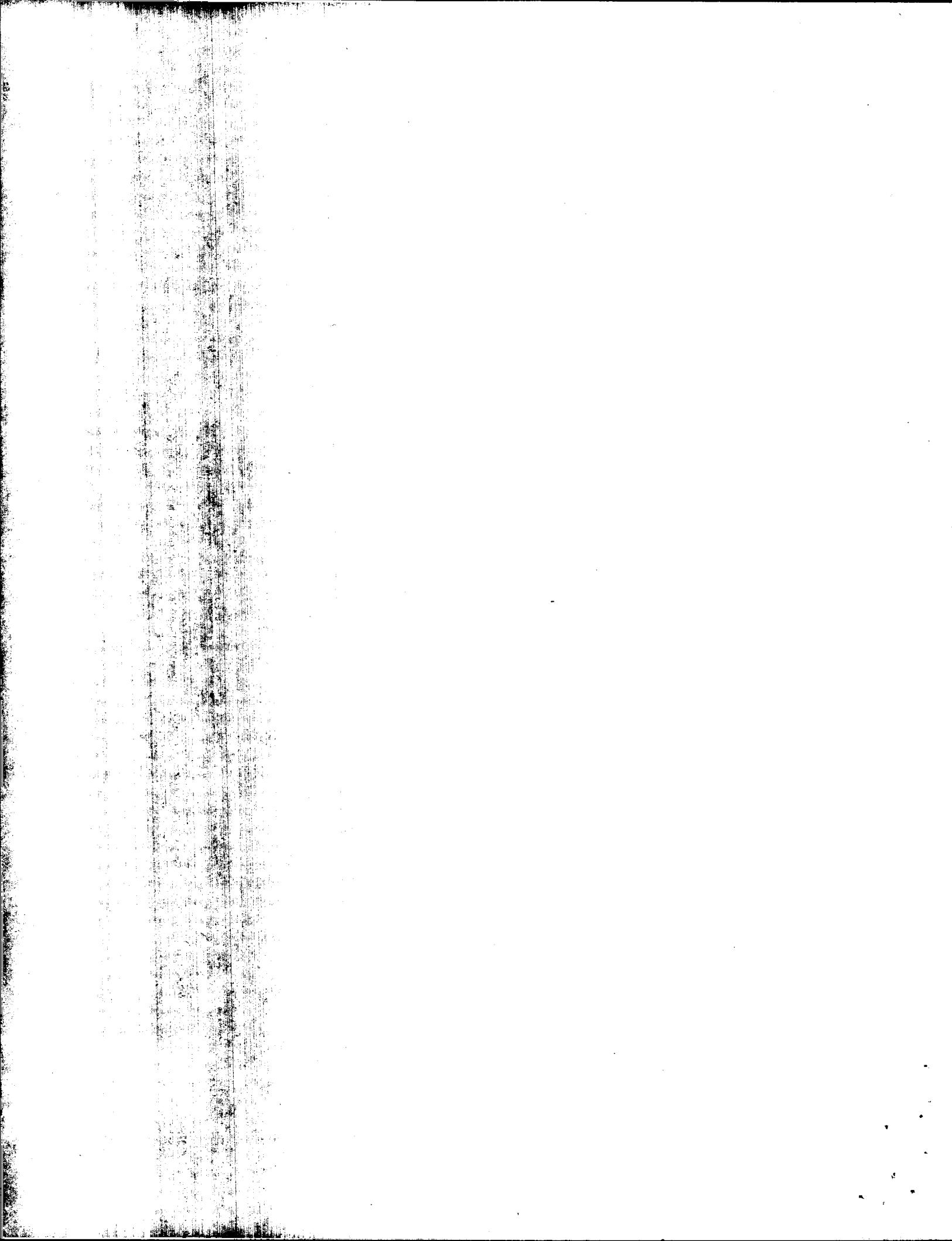
Importance: High

Hello Chantal,

Before we can ship the rearlockers at rev. F, (for order attached), we have to analyse the implications, so the confirmed dates no longer stand, since they were for revision E. As soon as the analysis is completed we will forward a new quote (if applicable) as well as the new delivery dates, unless you want them at Rev. E. Please advise ASAP as they are being produced at the moment. Thank you so much and have a nice day.

Jocelyne Laurin

Agente Service à la clientèle/Customer Service Agent
DELASTEK INC.
jlaurin@delastek.com



De : Chantal Lavoie [<mailto:clavoie@dartaero.com>]

Envoyé : 30 mars 2012 10:38

À : Jocelyne Laurin

Cc : Lacelle, Linda

Objet : ECN D2273

Hi Jocelyne,

Please see attached for new revision for rearlocker they are now at rev. F.

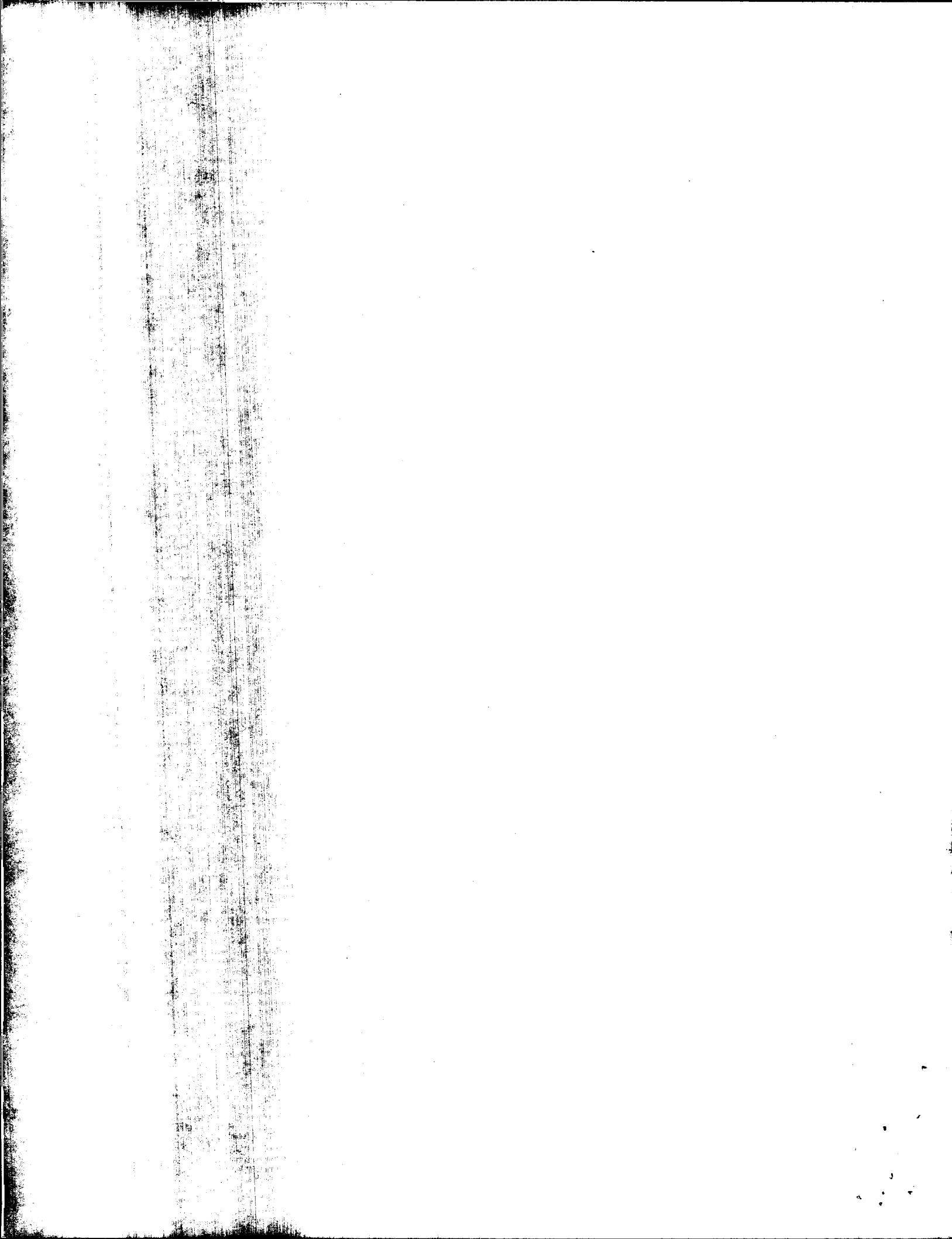
Thanks

Chantal

No virus found in this message.

Checked by AVG - www.avg.com

Version: 2012.0.1913 / Virus Database: 2114/4912 - Release Date: 04/03/12



**Certificate of Conformance****Solve Composites****29 Distribution Way****Plattsburgh, New York, 12901****USA****Dart Aerospace Order Number: 17636****Part Number: D2273****Quantity: 1****Drawing Number: D2273, DT8020****Serial Number (s): 0030, 0031, 0032, 0033, 0034****Date: September 24, 2012****Non-Conformances: None**

This is to certify that the parts identified above conform to all applicable drawings and/or specifications as evidenced by reports on file, and that all other purchase order and quality requirements have been met.

A handwritten signature of "Jerry Reyell" is written over a horizontal line. The signature is cursive and appears to be "Jerry Reyell".

Jerry Reyell**Project Manager****Solve Composites**